

Work Order ID 81849 -1

March-19-12 4:25:04 PM

\*81849\*

Page 1

Item ID: D4406-041

Revision ID:

Item Name: Fwd Wearplate Assembly

Start Date: 19/03/2012 Start Qty: 8.00

Required Date: 02/04/2012 Req'd Qty: 8.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: MLS

Date: 12/03/20

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4406	B								
100		0.00							
*100*									
Waterjet									
FLOW CNC Waterjet	Memo	0.00							
304 . 050	1-Cut as per dwg D4406-1 prog rev: B dwg rev: B								
	2-Deburr if required								
110									
*110*	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC									
Quality Control	Memo	0.00							

B / Jm 120404

B / Jm 120404

8

8

# Work Order ID 81849

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Page 2

Item ID: D4406-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fwd Wearplate Assembly

Stop **\*NS2\***

Start Date: 19/03/2012 Start Qty: 8.00

**\*8\***

Required Date: 02/04/2012 Req'd Qty: 8.00

**\*8\***

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*5/12/12*

*(XS)*

130

0.00

**\*130\***

Small Fab

Memo

0.00

Small Fab

Form as per dwg D4406

*6 6*

*Sp 12/10/10*

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*5/12/10*

*(+6) 6*

# Work Order ID 81849

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**\*81849\***

Page 3

Item ID: D4406-041

Revision ID:

Item Name: Fwd Wearplate Assembly

Start Date: 19/03/2012 Start Qty: 8.00

Required Date: 02/04/2012 Req'd Qty: 8.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

**\*150\***

Large Fab

Large Fab

Memo

Weld bar as per dwg  
A/R 2059b hardcoat Batch#: M121175

Weld bar to wearplate as per dwg  
A/R s.s. rod Batch#: M120013

0.00

0.00

(x4) MAL 12/04/26

160

**\*160\***

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

4x 12/04/26

165

**\*165\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/26/17

(x4)

# Work Order ID 81849

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Page 4

Item ID: D4406-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Wearplate Assembly

Start Date: 19/03/2012 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

0.00

\*170\*

Small Fab

Memo

0.00

Small Fab

Apply coating as per dwg D4406

B120858

AS 12-4-26 (4)

180

QC5- Inspect part completeness to step on W/O

0.00

\*180\*

QC

Memo

0.00

Quality Control

4 d 12-4-27

190

Identify as per dwg & Stock Location: EP-1

0.00

\*190\*

Packaging

Memo

0.00

Packaging

4x d 12-4-27



# Work Order ID 81849

March-19-12 4:25:04 PM

**\*81849\***

Page 5

Item ID: D4406-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fwd Wearplate Assembly

Stop **\*NS2\***

Start Date: 19/03/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

QC21- Final Inspection - Work Order Release

0.00


**\*200\***

QC

Memo

0.00

Quality Control

12/4/30 

12.4.27

# Picklist Print

March-19-12 4:25:07 PM

Page 1

Work Order ID: 81849

Parent Item: D4406-041

Parent Item Name: Fwd Wearplate Assembly

\*81849\*

\*D4406-041\*

Start Date: 19/03/2012

Required Date: 02/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 11.06.06 new issue EC verified by:DD  
12.02.06 as per dwg revPB1 DD verf:EC

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	191.1180	3.5	29.47368	29.5		
**													

\*M304S18GA\*

304/316 .050 Sheet

## Location

MAT020

## Loc Qty

191.118

## Loc Code

119032

10.3

119383

60.818

120604

120

121192

150

Each

0.0000

2

\*\*

D4407-1

\*D4407-1\*

Bar

Manufactured No

121192

TD / Jim 120404 (8)

16

(x8)

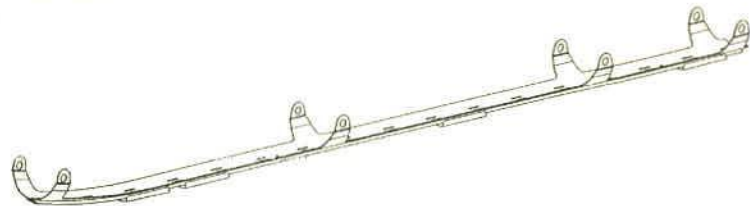
MAL

12/04/26

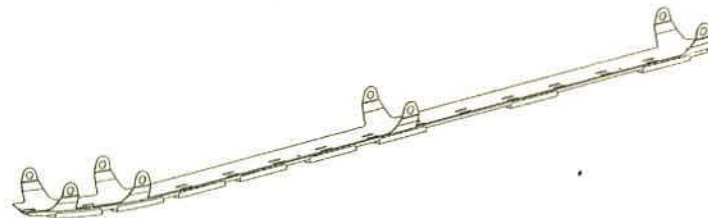
B 82876 x4  
B 81852 x4







D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	2		D4407-1	BAR
6		2	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

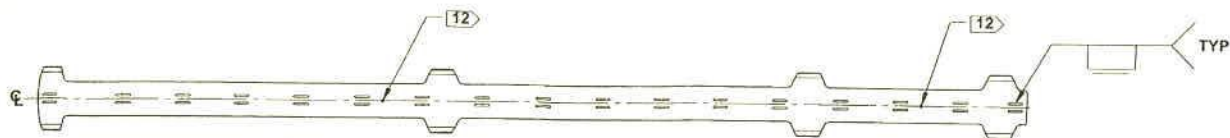
NO. 81849 MLJ

12/03/20

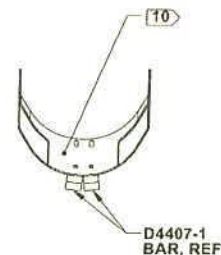
RELEASE  
2012-02-23  
MLJ

B	REVISE BILL OF MATERIAL, ADD NOTE 13/14 & REVISE NOTE 9 SHT 2 & 3, MODIFY DETAIL E & F (ZN B3-6, C2-6); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-3)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG APPR.	RF	D4406	SHEET 1 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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21849



# D4406-041 FWD WEARPLATE ASSY

SECTION A-A C3-2  
SCALE 2X

RELEASED  
2012-02-23  
MD

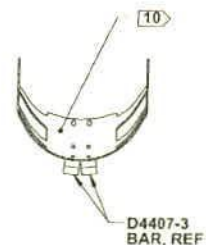
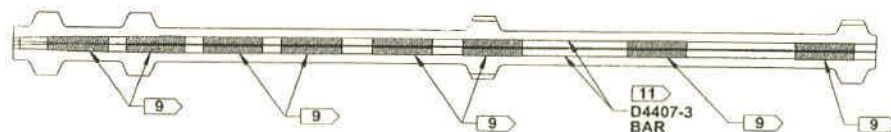
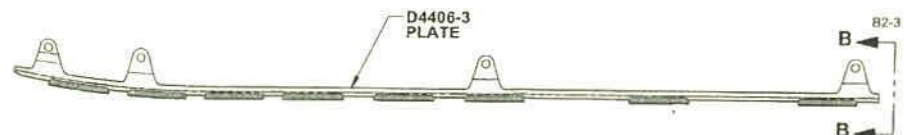
## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.40 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER  $\varnothing 0.188$  HOLES FROM D4406-1 TO D4407-1
- 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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# D4406-043 AFT WEARPLATE ASSY

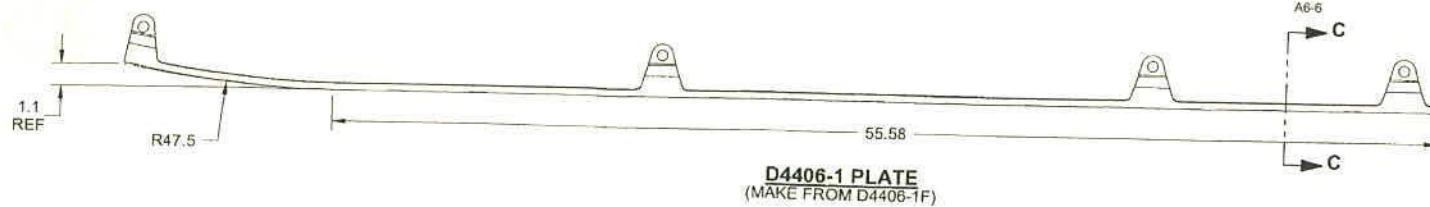
SECTION B-B C3-3  
SCALE 2X

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2012-02-23

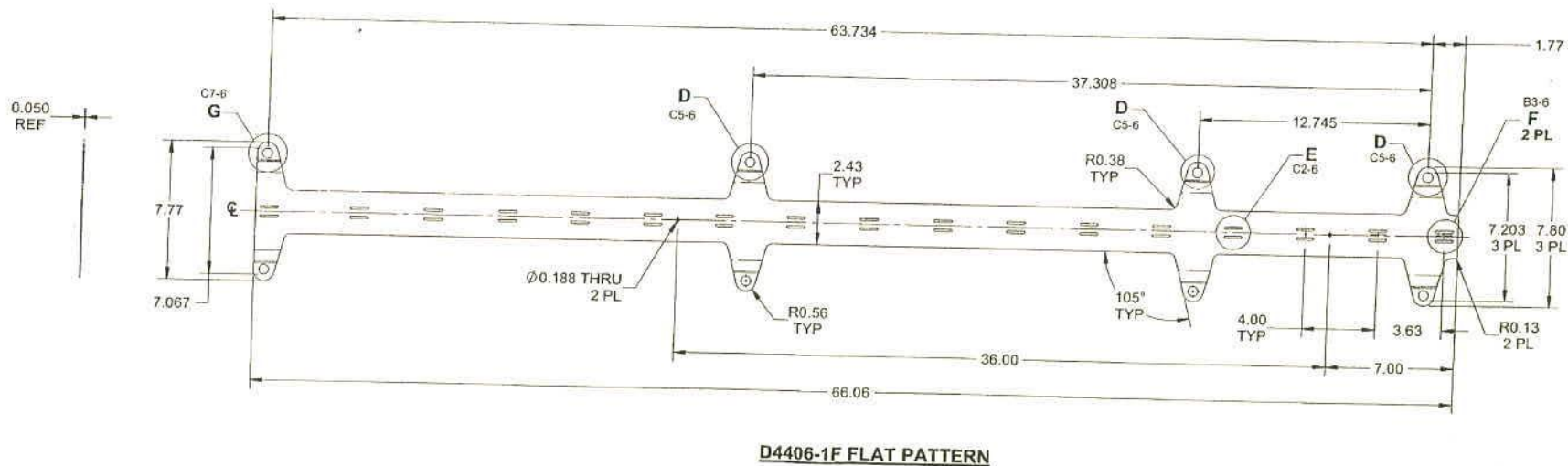
## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.73 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER  $\varnothing 0.188$  HOLES FROM D4406-3 TO D4407-3
- 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM TO D4406-3 PLATE

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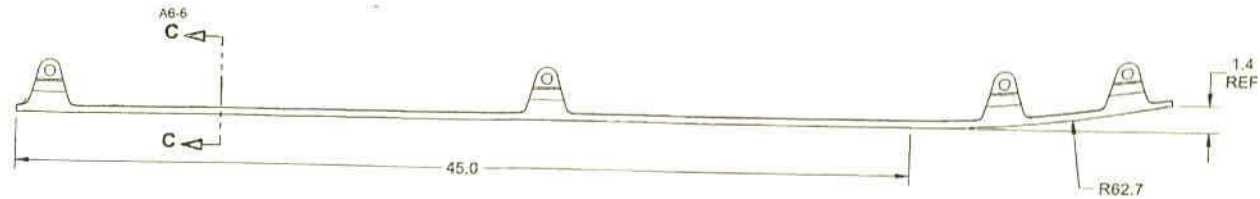


- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)  
PER AMS 5513 OR 5524  
OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 2.7 lbs

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R 2012-02-23 D  
NM

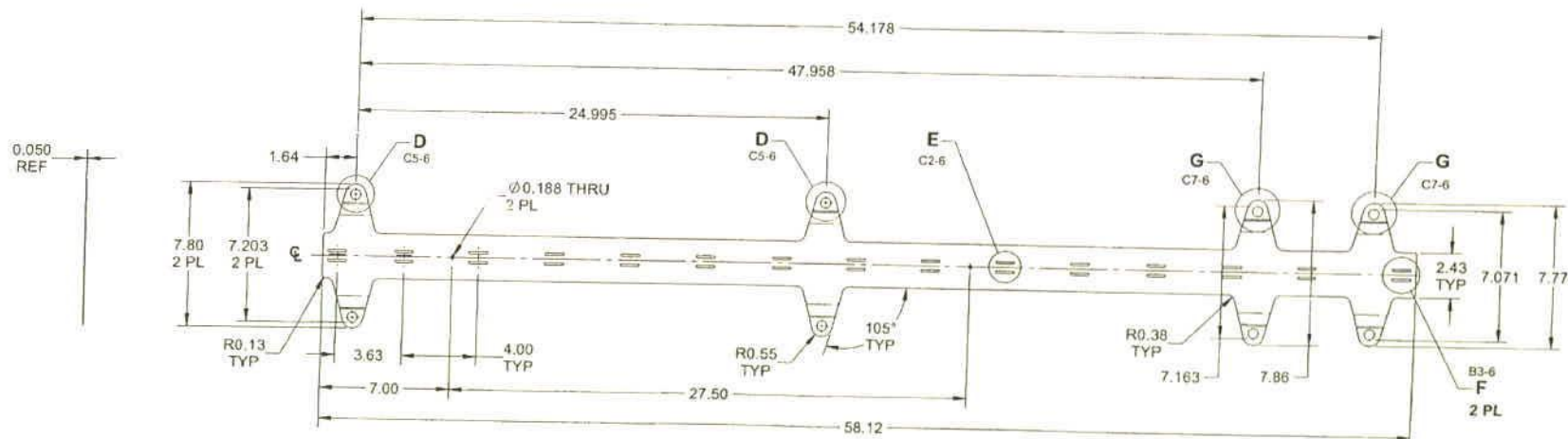
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**D4406-3 PLATE**  
(MAKE FROM D4406-3F)

81249



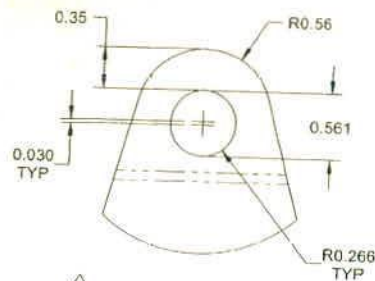
**D4406-3F FLAT PATTERN**

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R 2012-02-23  
M

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)  
PER AMS 5513 OR 5524  
OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.4 lbs

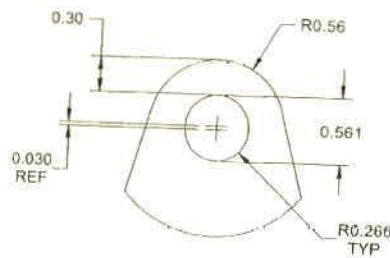
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4406	SHEET 5 OF 6
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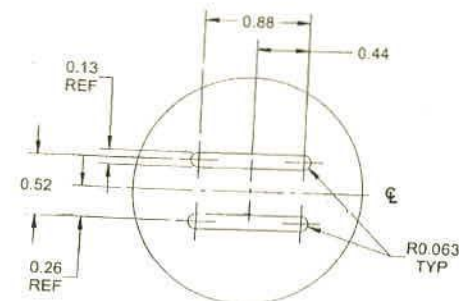
**DETAIL G**  
SLOT DETAIL TYP  
SCALE 6X

C7-4  
C2-5  
C3-5



**DETAIL D**  
SLOT DETAIL TYP  
SCALE 6X

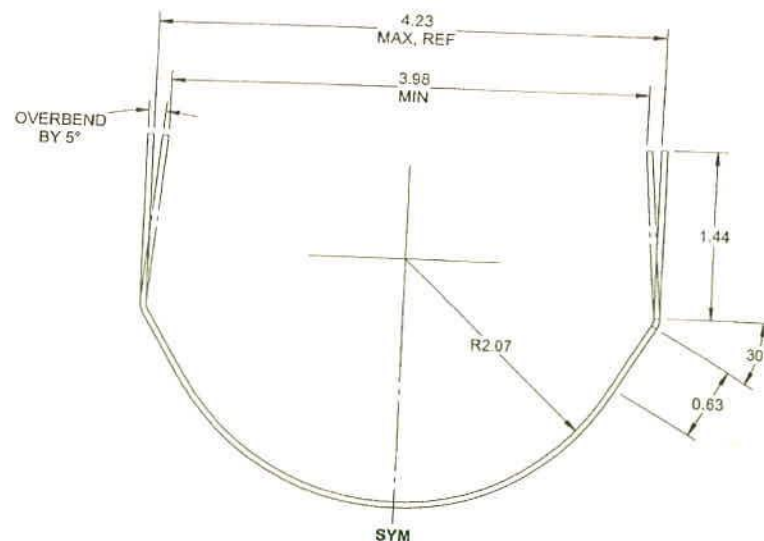
C2-4  
C3-4  
C5-4  
C6-5



B

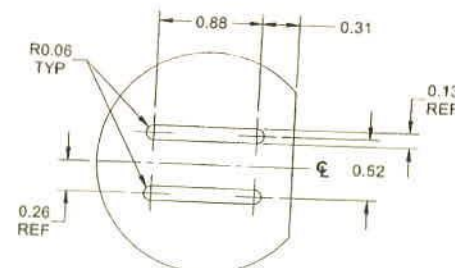
**DETAIL E**  
SLOT DETAIL TYP  
SCALE 6X

C2-4  
C4-5



**DETAIL C**  
DETAIL TYP  
SCALE 6X

D2-4  
D6-5



B

**DETAIL F**  
SLOT DETAIL TYP  
SCALE 6X

C1-4  
B1-5

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2012-02-23  
NTS

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D4406</b>	REV. B
MFG. APPR.	RF	TITLE <b>WEARPLATE ASSY</b>	SHEET 6 OF 6
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